



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2857-2

Job Sheet 185557



Part No: D2857-2

Job Qty: 10 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D 06.03.30

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-1		DAS 18/11/06
100	Bandsaw	10 pcs	11/9/18	11/9/18	0.00	1.74	Bandsaw1		52 18/11/06
110	CNC Vertical Machining	10 pcs	11/9/18	11/9/18	0.18	4.81	HAAS1-2		9-89 18/11/06
130	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-1		DR 18/11/12
140	HandFinish	10 pcs	11/9/18	11/9/18	0.00	0.19	HandFinish1		BEB 18-11-13
150	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC3		BEB 18-11-13
160	Powdercoat	10 pcs	11/9/18	11/9/18	0.00	0.14	Powdercoat1		38
170	QC	10 pcs	11/9/18	11/9/18	0.00	0.00	QC3		NOV 15 2018
180	Packaging	10 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		NOV 15 2018
190	QC21-SA	10 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks 4.425"

Descriptions: 110 - 1-Machine per folio FA940 FOLIO REV: C

160 - START TIME: 9:10

1138951 START: 9:10 TEMP: 320° FINISH: 9:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25	3.7000 ft (.37 ea)	90-Start up Operation	S105838 S125096

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X01.250	4	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches ± 0.010	4.310 4.290	4.302	
2	Hinge Bracket	4.000inches ± 0.010	4.010 3.990	4.001	
3	Hinge Bracket	0.340inches ± 0.010	0.350 0.330	0.339	
4	Hinge Bracket	1.110inches ± 0.005	1.115 1.105	1.110	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Suspected Unit: _____		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Small Fab ☐ Cross tube ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Water Jet ☐ Engineering Quality ☐ Other ☐																																																																																																																													
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Description Work Order Deviation								By _____																																																																																																																									
Dart Aerospace Ltd. 1270 Aberdeen Street Newnesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S125097 Part: D2857 - 2 Job No: 185557 Serial No/Batch: S125097 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's								Supervisor rification Coordinator roval																																																																																																																									
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5	Hinge Bracket	1.790inches $\pm$ 0.010	1.800 1.780	1.792
6	Hinge Bracket	1.320inches $\pm$ 0.005	1.325 1.315	1.320
7	Hinge Bracket	2.000inches $\pm$ 0.010	2.010 1.990	1.999
8	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	0.341
9	Hinge Bracket	0.447inches $\pm$ 0.010	0.457 0.437	0.446
10	Hinge Bracket	0.171inches $\begin{matrix} + 0.005 \\ - 0.000 \end{matrix}$	0.176 0.171	0.172
11	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	0.146
12	Hinge Bracket	0.376inches $\pm$ 0.010	0.386 0.366	0.380
13	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	0.126
14	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	0.063
15	Hinge Bracket	0.166inches $\begin{matrix} + 0.005 \\ - 0.000 \end{matrix}$	0.171 0.166	0.166
16	Hinge Bracket	0.911inches $\pm$ 0.010	0.921 0.901	0.915
17	Hinge Bracket	0.600inches $\pm$ 0.010	0.610 0.590	0.600
18	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	0.125
19	Hinge Bracket	0.150inches $\pm$ 0.010	0.160 0.140	0.150

Plex 10/30/18 11:31 AM Dart.lajeunesse.marie

DAS
52
9-89

18/11/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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